

Date: Tuesday, 12/5/2006 8:19:21 AM  
 User: Kim Johnston

## Process Sheet

|                       |                                       |  |                  |                             |  |  |
|-----------------------|---------------------------------------|--|------------------|-----------------------------|--|--|
| Customer              | : CU-DAR001 Dart Helicopters Services |  | Drawing Name     | : CASTING, SUPPORT BRACKET  |  |  |
| Job Number            | : 29807                               |  | Part Number      | : D2265                     |  |  |
| Estimate Number       | : 10935                               |  | Drawing Number   | : D2265 REV A               |  |  |
| P.O. Number           | : N/A                                 |  | Project Number   | : N/A                       |  |  |
| This Issue            | : 12/5/2006 S.O. No. : N/A            |  | Drawing Revision | : A                         |  |  |
| Prsht Rev.            | : NC                                  |  | Material         | : N/A                       |  |  |
| First Issue           | : N/A                                 |  | Due Date         | : 1/5/2007 Qty: 50 Um: Each |  |  |
| Previous Run          | : 29079                               |  |                  |                             |  |  |
| Written By            | : <u>KA</u>                           |  |                  |                             |  |  |
| Checked & Approved By | : <u>KA 06/12/05</u>                  |  |                  |                             |  |  |
| Comment               | : Est D 98.12.15 Added Dwg Rev DM     |  |                  |                             |  |  |

## Additional Product

Job Number:



| Seq. #:   | Machine Or Operation: | Description :  |
|---|-----------------------|--|
| 1.0   | PG                    | PURCHASING<br><span style="margin-left: 100px;"></span>                    |
| <b>Comment:</b> PURCHASING<br>Issue P/O: <u>2640</u> <span style="margin-left: 100px;"><u>C06112104</u></span><br>Cast parts per drawing D2265<br>Possible Supplier: Alpine Foundry<br>Material release note required |                       |  |
| 2.0   | D2265P                | Step Support Casting<br><span style="margin-left: 100px;"></span>          |
| <b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)<br>Step Support Casting   |                       |  |
| 3.0   | PACKAGING 1           | PACKAGING RESOURCE #1<br><span style="margin-left: 100px;"></span>         |
| <b>Comment:</b> PACKAGING RESOURCE #1<br>Recieve & Inspect for Transit Damage<br>Ensure Material Release Note is attached   |                       |  |
| 4.0   | QC6                   | DIMENSIONAL CHECK<br><span style="margin-left: 100px;"></span>             |
| <b>Comment:</b> DIMENSIONAL CHECK   |                       |  |
| 5.0   | SMALL FAB 1           | SMALL & MEDIUM FAB RESOURCE 1<br><span style="margin-left: 100px;"></span> |
| <b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1<br>Grind tips of castings as per Dwg D2265  |                       |  |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/01/02  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CASTING, SUPPORT BRACKET

Job Number: 29807

Part Number: D2265

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



*207-02-02 (7)*



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *51372*

*EB 07/02/02 (6)*

*PC 07/02/02 (5)*

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*SP 07/01/02*

Job Completion



*CL 07/01/02*

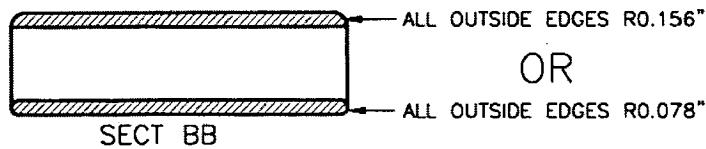
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

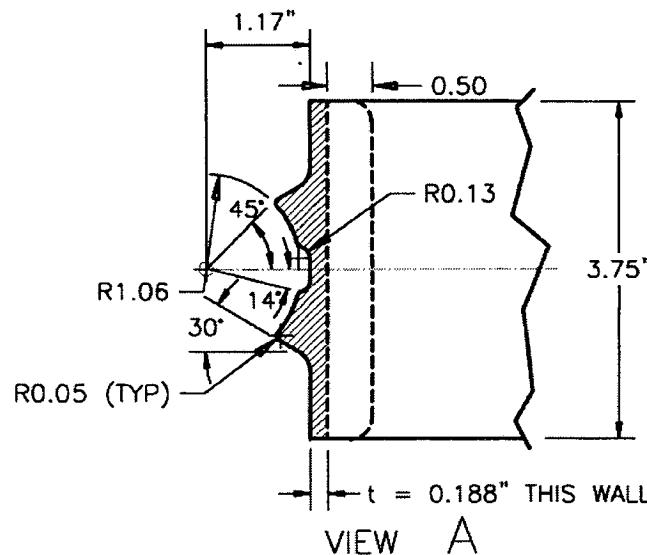
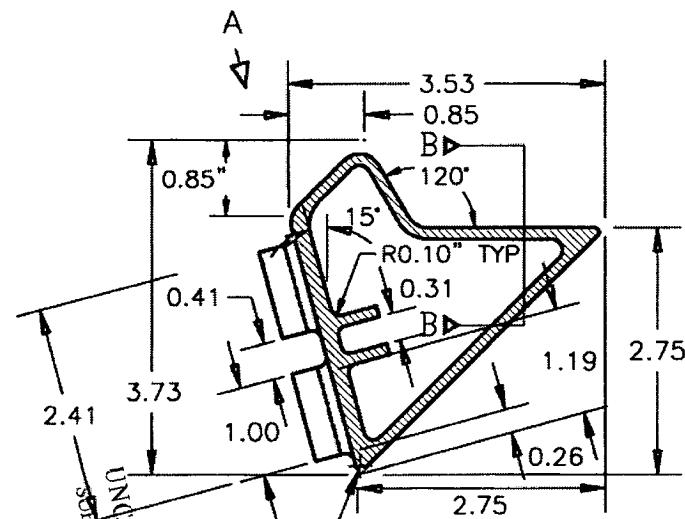
NOTE: Date & initial all entries

Copyright 1994 by DART AERO ACCESSORIES INC



UNDIMENSIONED OUTER RADII 0.375"  
UNDIMENSIONED INNER RADII 0.25"  
UNDIMENSIONED WALL THICKNESSES 5/32"

MATERIAL: CAST ALUMINUM  
ALLOY A356.2 (F)



PRO<sup>20</sup>  
PROP COPY  
RETURN TO  
ENGINEERING CO<sup>1</sup>  
CONTROLED CO<sup>1</sup>  
JECT TO AMENDME<sup>1</sup>  
WITHOUT NOTICE  
WORK ORDER  
NO. 20807

RELEASE  
46/06/27

**DART**



|               |          |  |              |
|---------------|----------|--|--------------|
| B. WILLIAMS   |          | DAR AERO ACCESSORIES INC               |              |
|               |          | VICTORIA INTERNATIONAL AIRPORT, CANADA |              |
| CHECKED       | APPROVED | D2265                                  | SHEET 1 OF 1 |
| DATE          | TITLE    | STEP SUPPORT CASTING                   | SCALE        |
| Aug. 18, 1994 |          |  | 1:2          |

**ALPINE NON-FERROUS FOUNDRY**  
8657-132ND STREET  
SURREY, B.C. V3W 4P1

**WORK ORDER**

Tel:(604) 596-8080      Fax: (604) 596-8045

**Sold To:** **DART AEROSPACE**  
1270 ABERDEEN STREET  
HAWKESBURY, ONT  
CANADA K6A 1K7

**Ship To:** **DART AEROSPACE**

| Order Date  | Purchase Order# | Due Date                   | Ship Via |         | Page |             |
|-------------|-----------------|----------------------------|----------|---------|------|-------------|
| 06-Dec-2006 | PO002640        | 29-Dec-2006                | FEDEX    |         | 1    |             |
| Item#       | Item Code       | Description                | Material | Ordered | PO   | Qty Shipped |
| 1           | DART D2265      | D2265 CSTG,SUPPORT BRACKET |          | 50      |      | 50          |
| 2           |                 |                            |          |         |      |             |

**Comments**

Castings&Patterns are property of Alpine until paid in full

Dec 20/06

DATE: 2006-06-19

**ALCAN INC**  
**Certificat d'analyse / Certificate of analysis**  
**USINE BEAUHARNOIS WORKS**



PAGE: 1

N° COMMANDE CLIENT / CUSTOMER ORDER NO.:  
R19966 / JUNE 1COMMANDE ALCAN (ITEM/QTA) / ALCAN ORDER NO.:  
355-0059049 001 01

N° D'EXPÉDITION / SHIP NO.: 6495  
 CONNAISSEMENT / BILL OF LADING: 327-087703-000  
 TRANSPORTEUR / CARRIER: GPGI000000

INPROHEAT INDUSTRIES LTD  
 CONSOLIDATED FAST FRATE INC.  
 4415 FAIRWAY, ATT. JOE OR BARBARA  
 PHONE: 514 639 7747  
 LACHINE, QC, CA  
 H8T 1B5

INPROHEAT INDUSTRIES LTD  
 680 RAYMUR AVE.  
 TEL. 604 254-0461  
 FAX: 604 254 6377  
 VANCOUVER, BC, CA  
 V6A 2R1

SCELLÉS / SEALS:

PRODUIT / PRODUCT: ALCAN 44512 A356.2  
 ALUMINUM INGOT

DIMENSION:

## ANALYSE EN % DU POIDS / ANALYSIS IN % OF WEIGHT

| NUMÉRO DE COULÉE<br>DROP NUMBER | #<br>ING | LOT #     | POIDS NET<br>(KG)<br>NET WEIGHT | PIÈCES | SI      | FE      | CU      | MN      | MG   | CR     | NI     | ZN     | TI   | PB      |
|---------------------------------|----------|-----------|---------------------------------|--------|---------|---------|---------|---------|------|--------|--------|--------|------|---------|
|                                 |          |           |                                 |        | NA      | CA      | LI      | SR      |      |        |        |        |      |         |
| 2229                            | 0815132  | 081513201 | 1011                            | 68     | 7.05    | 0.10    | < 0.01  | < 0.01  | 0.40 | < 0.01 | < 0.01 | < 0.01 | 0.11 | < 0.001 |
| 2207                            | 0815132  | 081513202 | 1001                            | 68     | 7.05    | 0.10    | < 0.01  | < 0.01  | 0.40 | < 0.01 | < 0.01 | < 0.01 | 0.11 | < 0.001 |
| 2248                            | 0815132  | 081513203 | 1020                            | 68     | 7.05    | 0.10    | < 0.01  | < 0.01  | 0.40 | < 0.01 | < 0.01 | < 0.01 | 0.11 | < 0.001 |
| 2231                            | 0815132  | 081513204 | 1012                            | 68     | 7.05    | 0.10    | < 0.01  | < 0.01  | 0.40 | < 0.01 | < 0.01 | < 0.01 | 0.11 | < 0.001 |
| 2248                            | 0815132  | 081513205 | 1020                            | 68     | 7.05    | 0.10    | < 0.001 | < 0.001 | 0.40 | < 0.01 | < 0.01 | < 0.01 | 0.11 | < 0.001 |
| 2264                            | 0815132  | 081513206 | 1027                            | 68     | 7.05    | 0.10    | < 0.001 | < 0.001 | 0.40 | < 0.01 | < 0.01 | < 0.01 | 0.11 | < 0.001 |
| 2244                            | 0815132  | 081513207 | 1018                            | 68     | 7.05    | 0.10    | < 0.001 | < 0.001 | 0.40 | < 0.01 | < 0.01 | < 0.01 | 0.11 | < 0.001 |
| 2237                            | 0815132  | 081513208 | 1015                            | 68     | 7.05    | 0.10    | < 0.001 | < 0.001 | 0.40 | < 0.01 | < 0.01 | < 0.01 | 0.11 | < 0.001 |
| 2237                            | 0815132  | 081513209 | 1015                            | 68     | 7.05    | 0.10    | < 0.001 | < 0.001 | 0.40 | < 0.01 | < 0.01 | < 0.01 | 0.11 | < 0.001 |
|                                 | 0815132  | 081513210 | 1013                            | 68     | 7.05    | 0.10    | < 0.001 | < 0.001 | 0.40 | < 0.01 | < 0.01 | < 0.01 | 0.11 | < 0.001 |
|                                 |          |           |                                 |        | < 0.001 | < 0.001 | < 0.001 | < 0.001 |      |        |        |        |      |         |

PAQUETS:

POIDS  
NET  
WEIGHT

PIÈCES

COURROIE:

BOIS:

POIDS BRUT:

BUNDLES:

STRAP:

WOOD:

GROSS WEIGHT:

LES LINGOTS TRI-LOK 25 KG. LES LINGOTS EN FORME DE T. LES GUEUSES. LES LINGOTS DE LAMINAGE MIS AU REBUT ET AUTRES LINGOTS DE REFUSION ONT TENDANCE À FORMER DES CAVITÉS SUSCEPTIBLES D'ÉMPRISONNER DE L'EAU. POUR ÉLIMINER L'HUMIDITÉ AVANT LEUR EMPLOI DANS TOUT PROCÉDÉ DE FUSION ET POUR PRÉVENIR LES RISQUES D'EXPLOSION, LES LINGOTS DEVEURONT ÊTRE SOUMIS À UN SÉCHAGE INTENSIF PAR CHAUFFAGE PRÉLIMINAIRE AVANT DE LES INCORPORER À DU MÉTAL EN FUSION. TRI-LOK 25 KG INGOT, TEE INGOT, SOWS, SCRAPPED SHEET INGOT AND OTHER INGOT FOR REMELTING ARE PRONE TO THE FORMATION OF SHRINKAGE CAVITIES WHICH WILL PERMIT ENTRAPMENT OF WATER. TO ELIMINATE MOISTURE PRIOR TO USE IN ANY MELTING OPERATION AND TO SAFEGUARD AGAINST POSSIBLE EXPLOSION HAZARDS, INGOTS SHOULD BE THOROUGHLY DRIED BY PREHEATING BEFORE LOADING THEM INTO MOLTEN METAL.

NORMAND PRIVE

L'EXACTITUDE DE CES ANALYSES EST DANS LES NORMES DES LIMITES COMMERCIALES.  
 THE ANALYSES HEREIN ARE ACCURATE WITHIN COMMERCIAL LIMITS.